

Date: Tuesday, 2/26/2008 8:01:16 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 37625	
Estimate Number : 12731	
P.O. Number :	Part Number : D353535
This Issue : 2/26/2008 S.O. No. :	Drawing Number : D3535 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 36425	Material :
Written By :	Due Date : 3/31/2008 Qty: 12 Um: Each
Checked & Approved By : <u>JA 08 02 26</u>	
Comment : Est Rev:A New Issue 07-02-15 JLM	
Est Rev:B As per Rev B 07-08-31 JLM Verified By:EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
-----	-----------	--------------------



Comment: Qty.: 0.8423 sf(s)/Unit Total : 10.1077 sf(s)

304/316 .040 Sheet

(M304S20GA)

Batch: 106748 IB 8-3-4

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3535

Dwg Rev: BProg Rev: BIB 8-3-4

(13)

2-Deburr if necessary IB 8-3-4

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

IB 8-3-4

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

1 08/03/04 (13)

5.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Deburr if necessary

2-Form on Brake as per Dwg D3535 using Jigs DT8261 and DT8326.

3-Identify as D3535-35.

IB 08/03/12 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: AD Date: 01/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/26/2008 8:01:16 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 37625

Part Number: D353535

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/03/12 (13)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FR 08/03/13 (13)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-13 (13)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-17

08-02-13 (13)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/13

Job Completion



mi 2008/3/13 (13)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order:	37625
Description: Wearshoe		Part Number:	D3535-35
Inspection Dwg: D3535	Rev: B	Page 1 of 1	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	*			
1.885	+/-0.010	1.888	*			
6.00	+/-0.030	6.003	*			
6.75	+/-0.030	6.75	*			
Ø0.188	+0.005/-0.001	.190	*			
23.250	+/-0.010	23.250	*			
19.750	+/-0.010	19.750	*			
17.750	+/-0.010	17.750	*			
14.250	+/-0.010	14.250	*			
9.500	+/-0.010	9.500	*			
4.750	+/-0.010	4.750	*			
0.300	+/-0.010	.303	*			
0.300	+/-0.010	.303	*			
0.038	+/-0.010	.038	*			

Measured by: LB	Audited by: [Signature]	Prototype Approval:	N/A
Date: 8-3-4	Date: 06/03/04	Date:	N/A

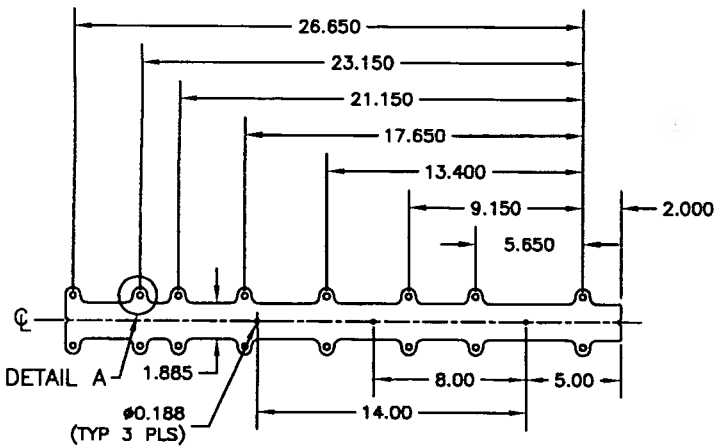
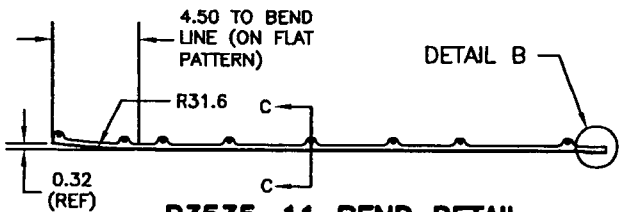
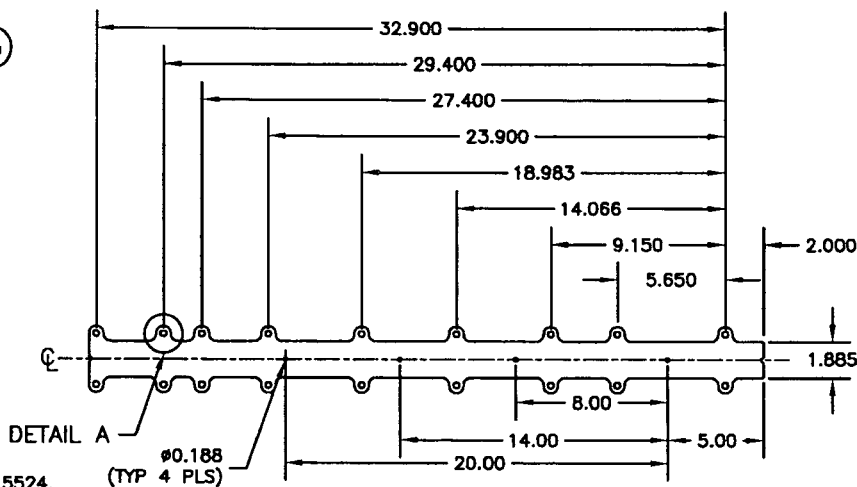
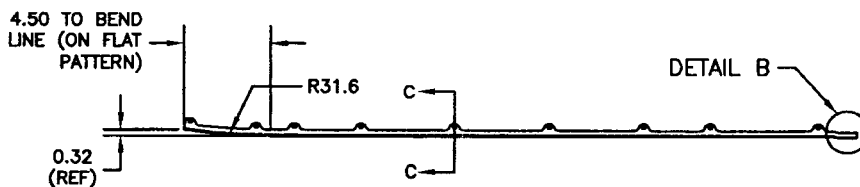
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM [Signature]	[Signature]

**DART**

RELEASED

07.04.24

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CB	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
<i>[Signature]</i>	<i>[Signature]</i>	D3535
DATE	TITLE	REV. B
07.04.17	WEARSHOE	SHEET 1 OF 7
A	06.10.25	NEW ISSUE
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC

**D3535-11F FLAT PATTERN****D3535-11 BEND DETAIL****D3535-13F FLAT PATTERN****D3535-13 BEND DETAIL****NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

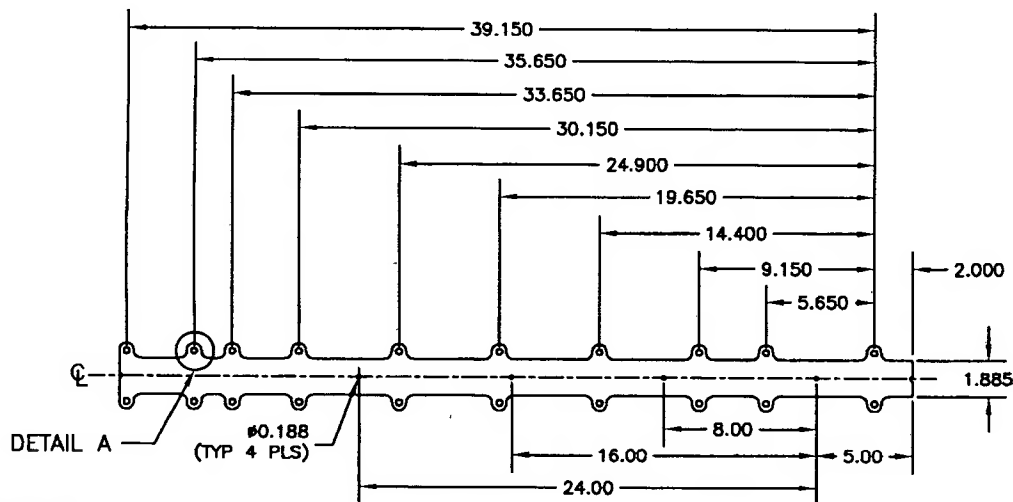
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WORK ORDER  
7625

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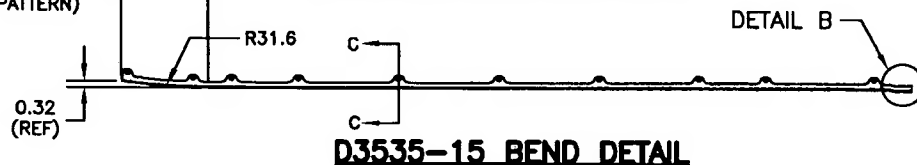
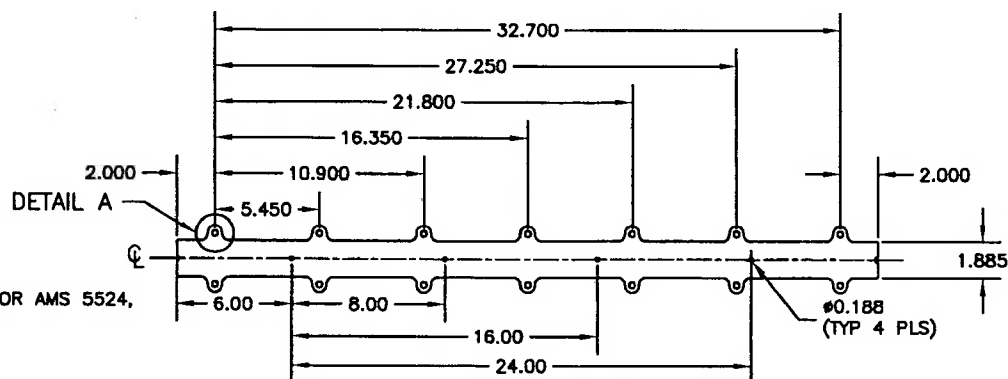
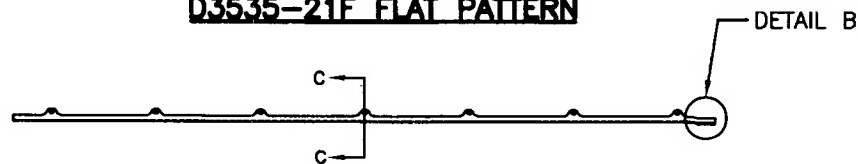
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DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 2 OF 7
				SCALE 1:10



4.50 TO BEND  
LINE (ON FLAT  
PATTERN)

**D3535-15F FLAT PATTERN****D3535-15 BEND DETAIL****D3535-21F FLAT PATTERN****D3535-21 BEND DETAIL**

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**NOTES**

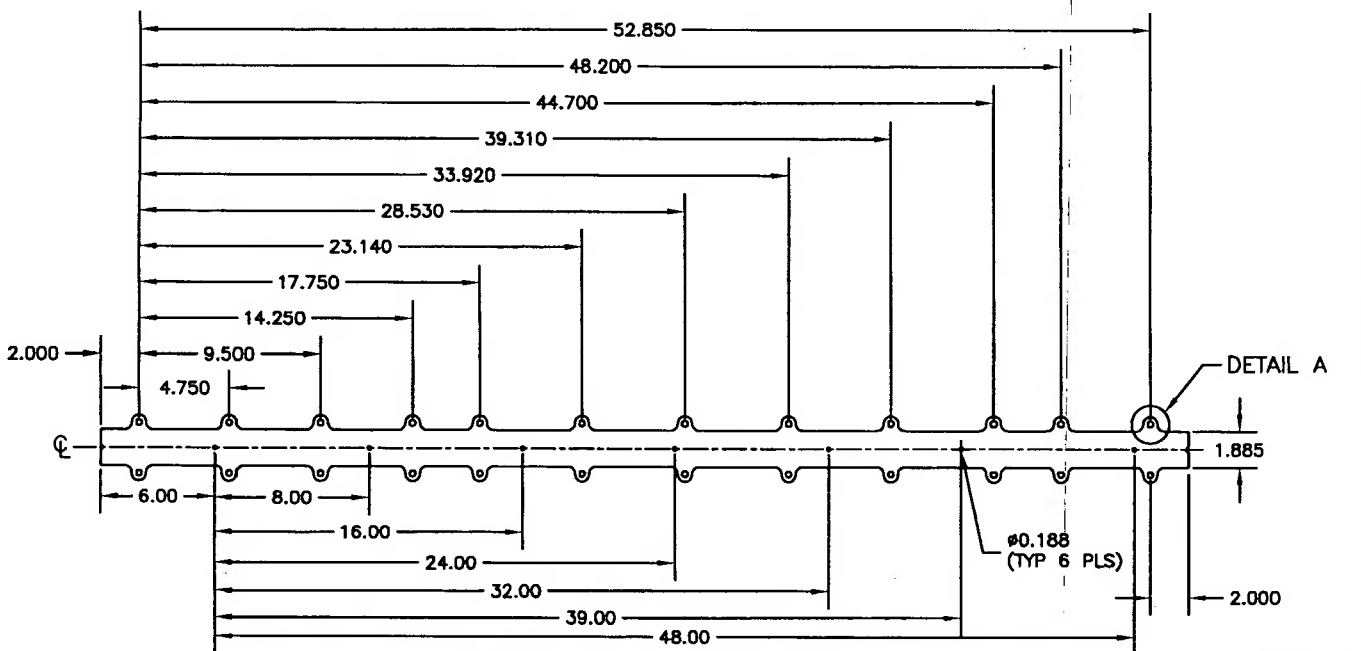
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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- 8) SEE PAGE 7 FOR DETAILS AND SECTION

**DART**

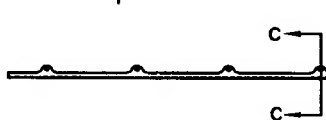
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 3 OF 7
				SCALE
				1:10

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07.04.24



**D3535-23F FLAT PATTERN**

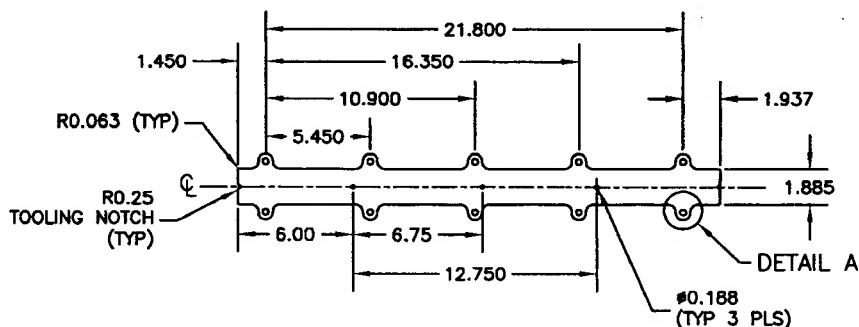


**D3535-23 BEND DETAIL**

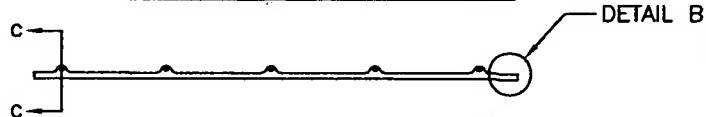
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**D3535-25F FLAT PATTERN**



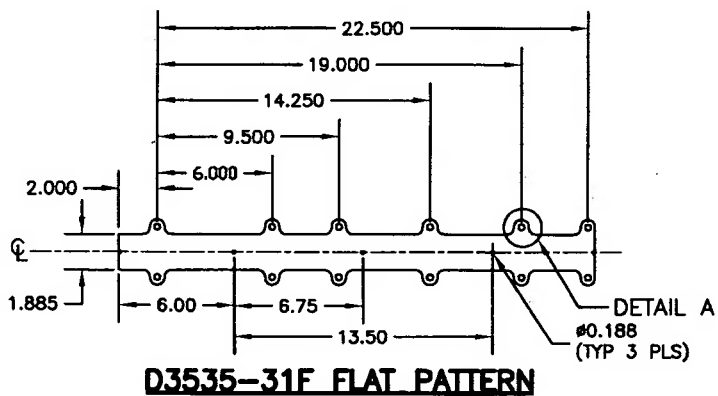
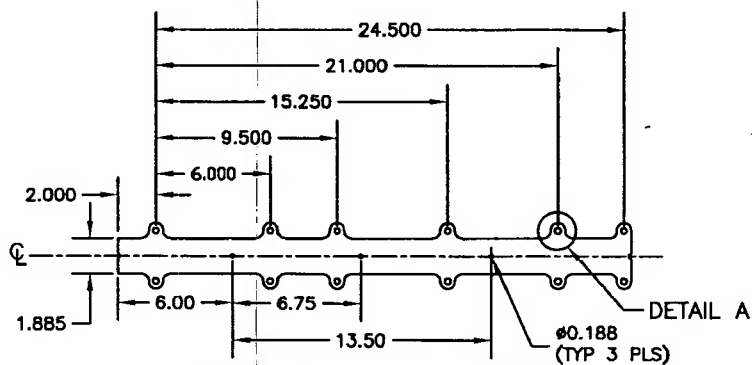
**D3535-25 BEND DETAIL**



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**D3535-31F FLAT PATTERN****D3535-31 BEND DETAIL****D3535-33F FLAT PATTERN****D3535-33 BEND DETAIL**

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CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
		TITLE	WEARSHOE	SHEET 4 OF 7
		SCALE	1:10	

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**NOTES**

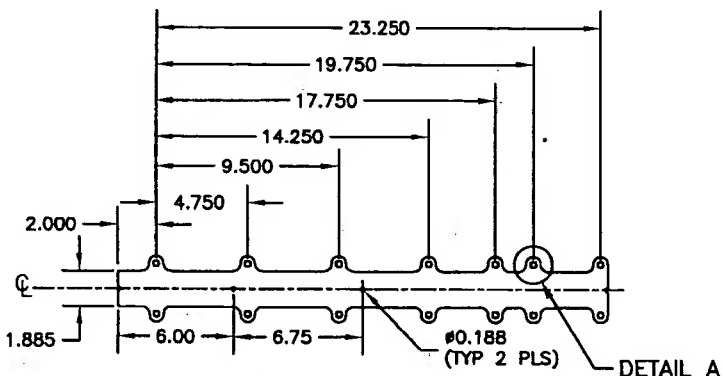
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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C.B.	MH	PORT HADLOCK, WA	
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		D3535	
DATE	TITLE	SCALE	
07.04.17	WEARSHOE	1:10	



**D3535-35F FLAT PATTERN**

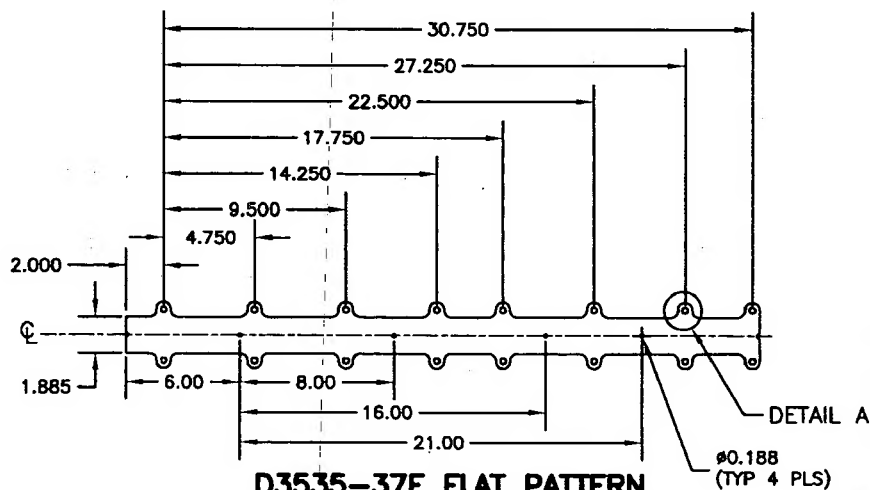


**D3535-35 BEND DETAIL**

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**NOTES**

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**D3535-37F FLAT PATTERN**



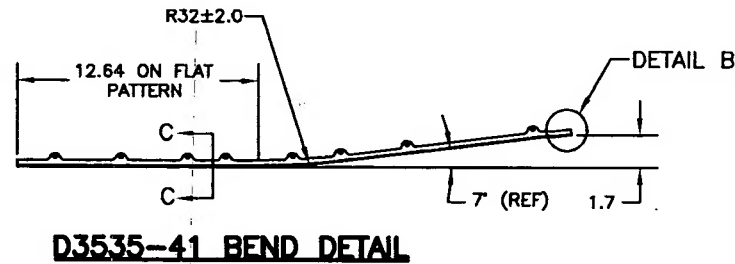
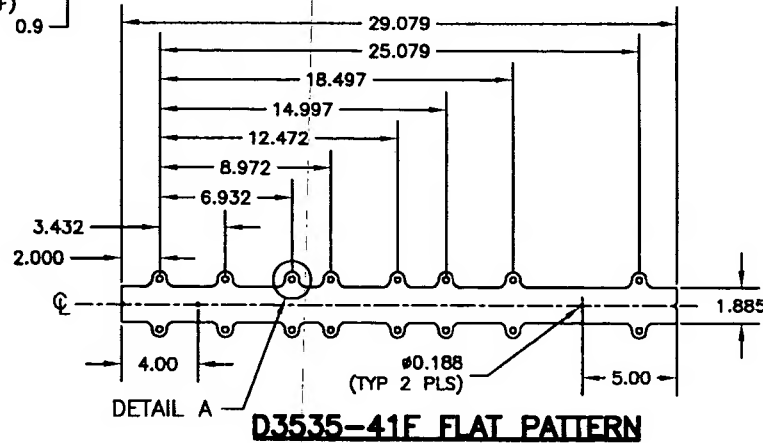
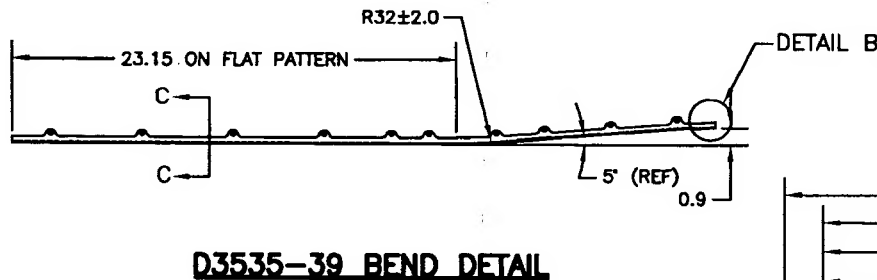
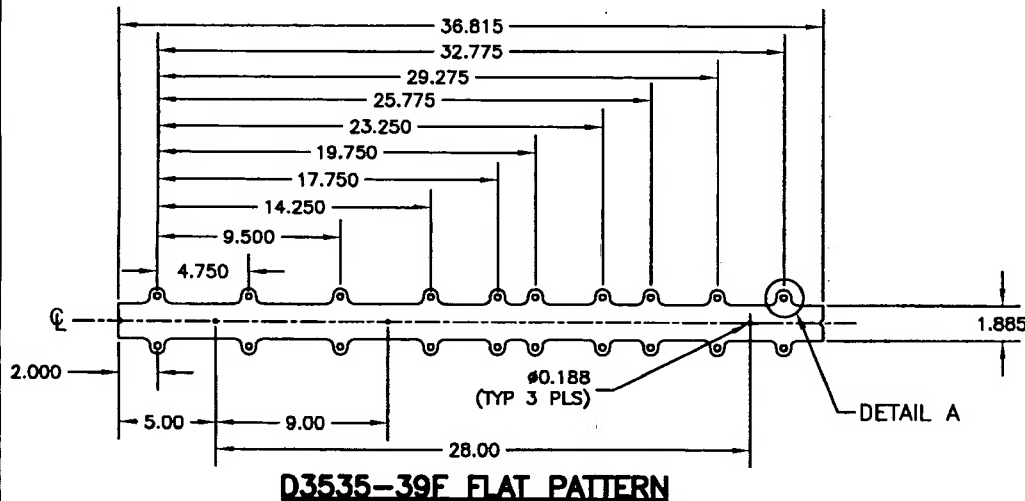
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		TITLE	WEARSHOE	SHEET 6 OF 7
				SCALE 1:10



**NOTES**

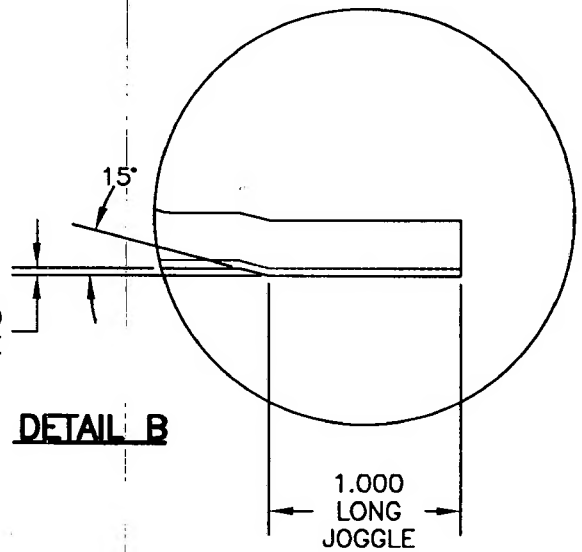
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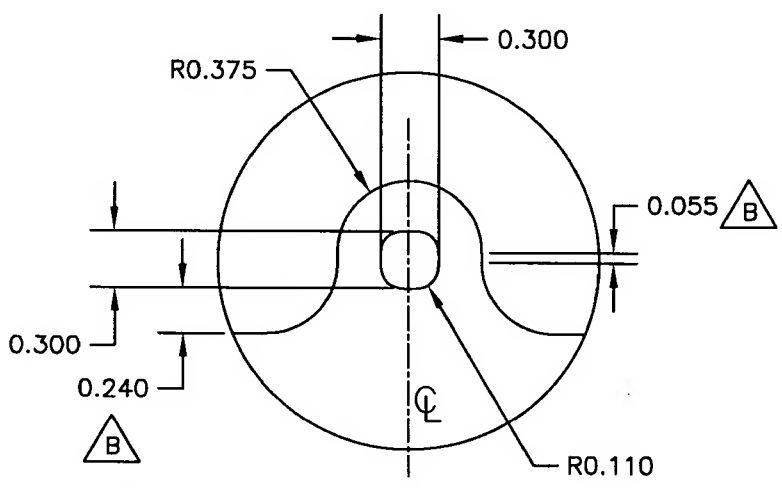


DESIGN	C.B.	DRAWN BY	PH	DART AEROSPACE USA, INC.	REV. B
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA	
DATE	07.04.17	TITLE	WEARSHOE	DRAWING NO. D3535	SHEET 7 OF 7
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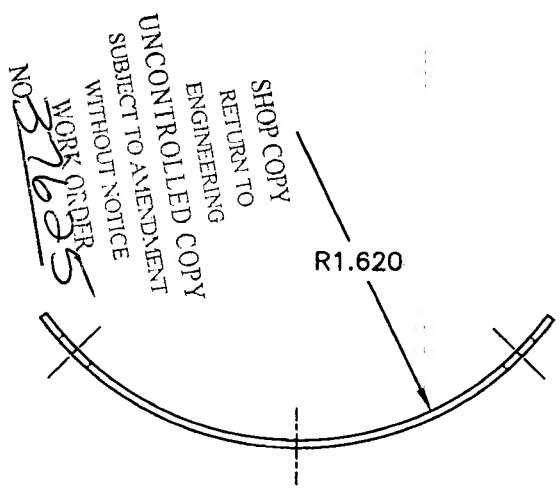
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07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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